

Date: Monday, 8/21/2006 2:13:12 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RING		
Job Number	: 28267B		Part Number	: D29685		
Estimate Number	: 10395		Drawing Number	: D2968		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 8/21/2006 S.O. No. : N/A		Drawing Revision	: B1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 9/20/2006 Qty: 40 Um: Each		
Previous Run	: 27924B					
Written By	:					
Checked & Approved By	:					
Comment	: Est:C 03.04.11		Reformat; Incorporated D2968-1/5 KJ/RF			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4130NT3000W500	4130 Tube 3"ODx.5"W  <b>Comment:</b> Qty.: 0.0218 f(s)/Unit Total : 0.8736 f(s) Material: AISI 4130 Ø 3/4" Bar <u>3.00" x W.500"</u> <u>Spf.</u> (M4130N-R0.750) Batch: <u>M102020</u> <span style="float: right;">S.G 06/09/07</span>
2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE  <b>Comment:</b> MORI SEIKI LATHE 1-Turn Blank as per Folio FA049 and Dwg D2968 2-Deburr, no sharp edges <u>Issue to Turn per Dwg D2968</u> <u>2003</u> <span style="float: right;">06-09-07</span>
3.0	QC5	INSPECT PARTS AS THEY COME OFF MACHINE  <b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;">S.G 06/09/07 40</span>
4.0	QC8	SECOND CHECK  <b>Comment:</b> SECOND CHECK <span style="float: right;">N/A</span>
5.0	PACKAGING 1	PACKAGING RESOURCE #1  <b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: <u>St 396</u> <u>Pack 1 (yu)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

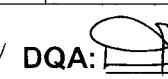
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

 No
  DQA: 

Date: 06/09/21

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 28267B

Part Number: D29685

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 DC

DOCUMENT CONTROL



(yes)

Comment: DOCUMENT CONTROL

Inspection Level 21

8/21/06

Job Completion



U Sh. 8/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

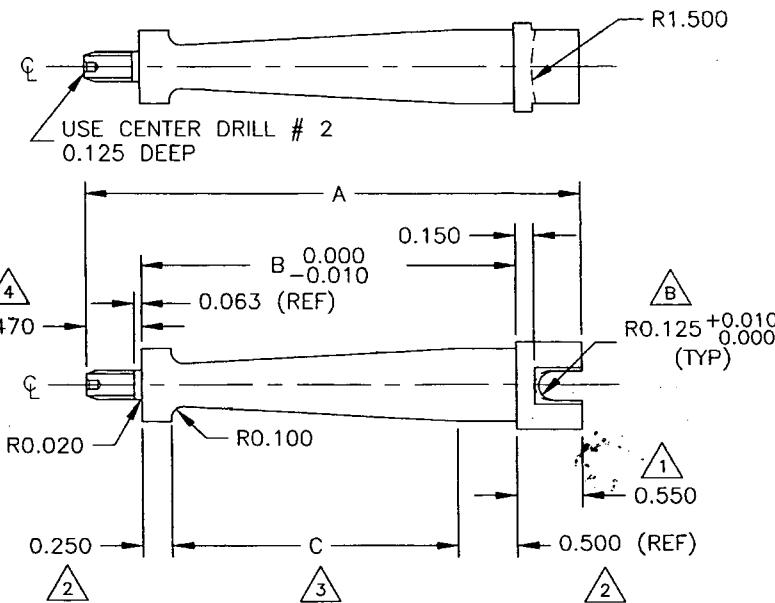
DART AEROSPACE LTD	Work Order:	28267B
Description: Tow Ring	Part Number:	D2968-5
Inspection Dwg: D2968	Rev: B1	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by:	<u>BS</u>	Audited by:	<u>J.G</u>	Prototype Approval:	N/A
Date:	06/09/21	Date:	06/09/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	P/O D2968-041/-043	KJ/RF <del>✓</del> <del>✓</del>



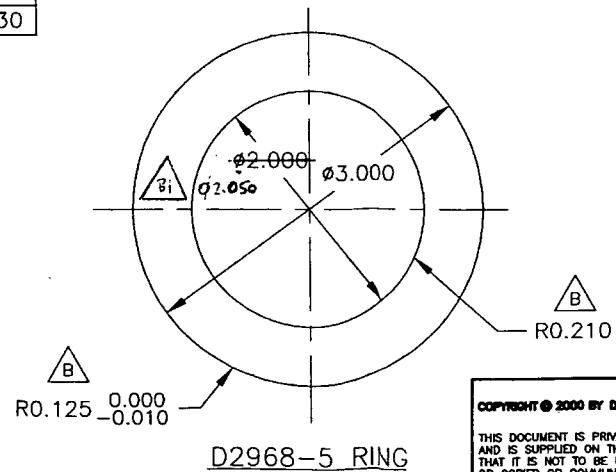
PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1 / -3 STEM

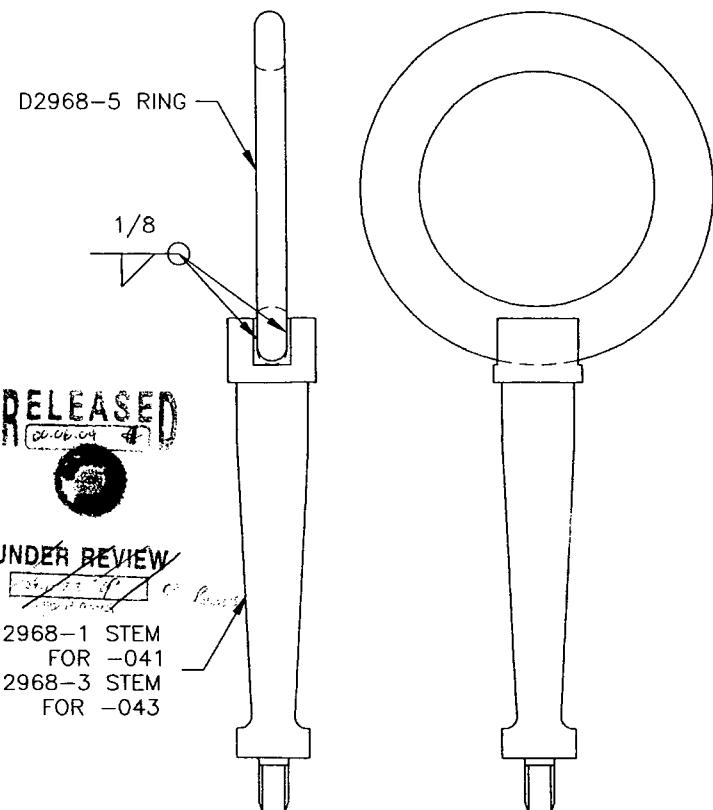
WORK ORDER NO 2968-1  
 ENGINEER: D2968-1  
 RETURN TO: SHOP COPY  
 UNCONTROLLING: MATERIAL: AISI 4130  
 SUBJECT TO AMENDMENT: Ø0.750 O.D.  
 WITHOUT NOTICE: Ø0.625 O.D.

△ MACHINE UNIFORM TAPER FROM Ø0.363 O.D.  
 TO Ø0.625 O.D.  
 △ 1/4-28 UNF THREAD WITH 0.063 C.R.P.  
 MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS  
 UNLESS OTHERWISE INDICATED  
 TOLERANCES ARE PER DART QSI 018 UNLESS  
 OTHERWISE NOTED

**D2968-5 RING:**  
 MATERIAL AISI 4130  
 TOLERANCES ARE PER DART QSI 018 UNLESS  
 OTHERWISE NOTED



D2968-5 RING



**D2968-041 AND D2968-043 TOW RING:**  
 WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING  
 HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI  
 FINISH: CAD PLATE ENTIRE ASSEMBLY PER  
 QQ-P-416F CLASS I TYPE II  
 POWDER COAT WHITE (REF 4.3.5.2) PER DART  
 QSI 005 4.3 (EXCEPT THREADS)  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	DRAWN BY	DART
CHECKED	APPROVED	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B SHEET 1 OF 1 SCALE 1:1
00.05.31	TOW RING	

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 DART AEROSPACE LTD.



## CERTIFICATE OF CONFORMITY

**SOLD TO:**

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

**SHIPPED TO:**

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	DSK101	Support as per Dwg DSK101 D6103-003 B 28318	1987
20	DSK101	Support as per Dwg DSK101 D6103-003 B 28319	1987
40	D2968-5	Ring M4130NT3000W500 M102020 W/O 28267B	1987
20 22	D2968-5	Ring M4130NT3000W500 M102020 W/O 28268B	1987
20 22	D3407-5	Ring M174R3000 M18742 W/O 28333	1987

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shig (Regular) Walz

Shig (Regular) Walz

Vankleek Hill September 20, 2006